

Date: Thursday, 6/15/2006 1:56:06 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP SPACER
<b>Job Number</b> : 27590A	
<b>Estimate Number</b> : 10375	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D30651
<b>This Issue</b> : 6/15/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3065 REV. A2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 6/15/2006 <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A2
<b>Previous Run</b> : 26928A	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 7/2/2006
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	<b>Qty:</b> 60 <b>Um:</b> Each
<b>Comment</b> : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est:D 06.04.25 Water jet EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.1300 sf(s)/Unit Total: 7.7994 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M10/417

M10/417 06 07 10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3065

Dwg Rev: A2

Prog Rev: A2

2-Deburr as required

M10/417 06 07 10 (60)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M10/417 06 07 10 (60)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

M10/417 06 07 11 (60)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAP 06:07:12 (50)

P10  
58

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-11	2	2 parts scrap due to W.J. 1- hole damage 2- bottom hole spacing too wide	<i>[Signature]</i> SAD	destroy	SAD 06-07-11	<i>[Signature]</i> 06-07-11	<i>[Signature]</i> 06-07-11	<i>[Signature]</i> 06-07-11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:56:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27590A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 06/08

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-14

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06/08/14 (58)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/8/30 (58)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5121

06/8/30 (58)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/31 (58)

Completion



C 06/08/30

NOTE: Date & Initials  
Hi-Q Quality Assurance approved forms (CRITICAL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Initial all entries

QC



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	#	APPROVED	#	DRAWING NO. D3065	SHEET 1 OF 5
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY	SCALE	1:2
A	02.09.11	NEW ISSUE			
A1	03.02.13 CP	ADD SLOTS TO D3065-5			
A2	03.02.27 CP	0.531 WAS 0.410			

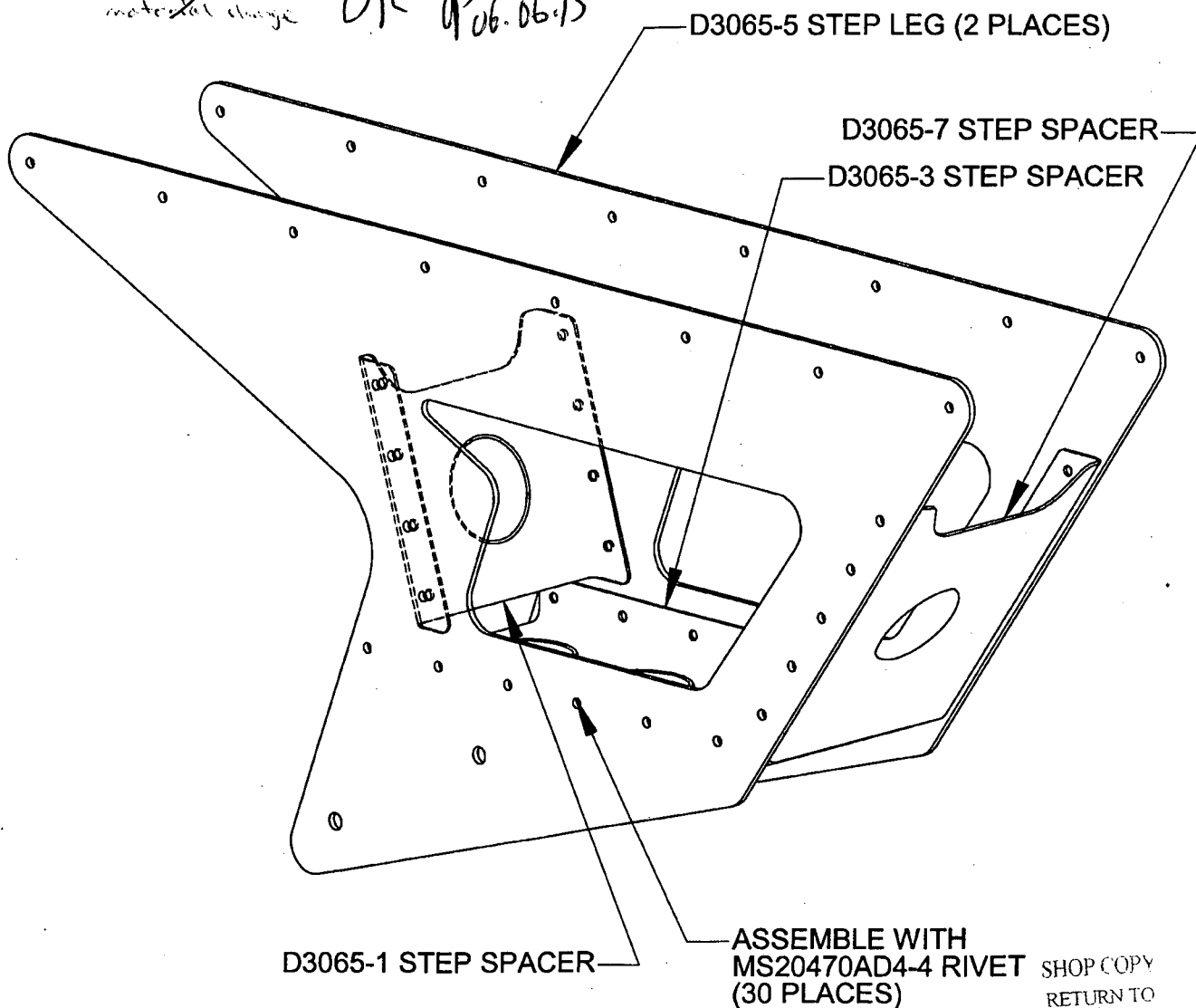
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02.01.20 #

UNDER REVIEW

06.06.02 CB

material change

O/L P.06.06.15



## D3065-041 STEP LEG ASSEMBLY

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WITHOUT NOTICE  
WORK ORDER  
NO. 27590 A

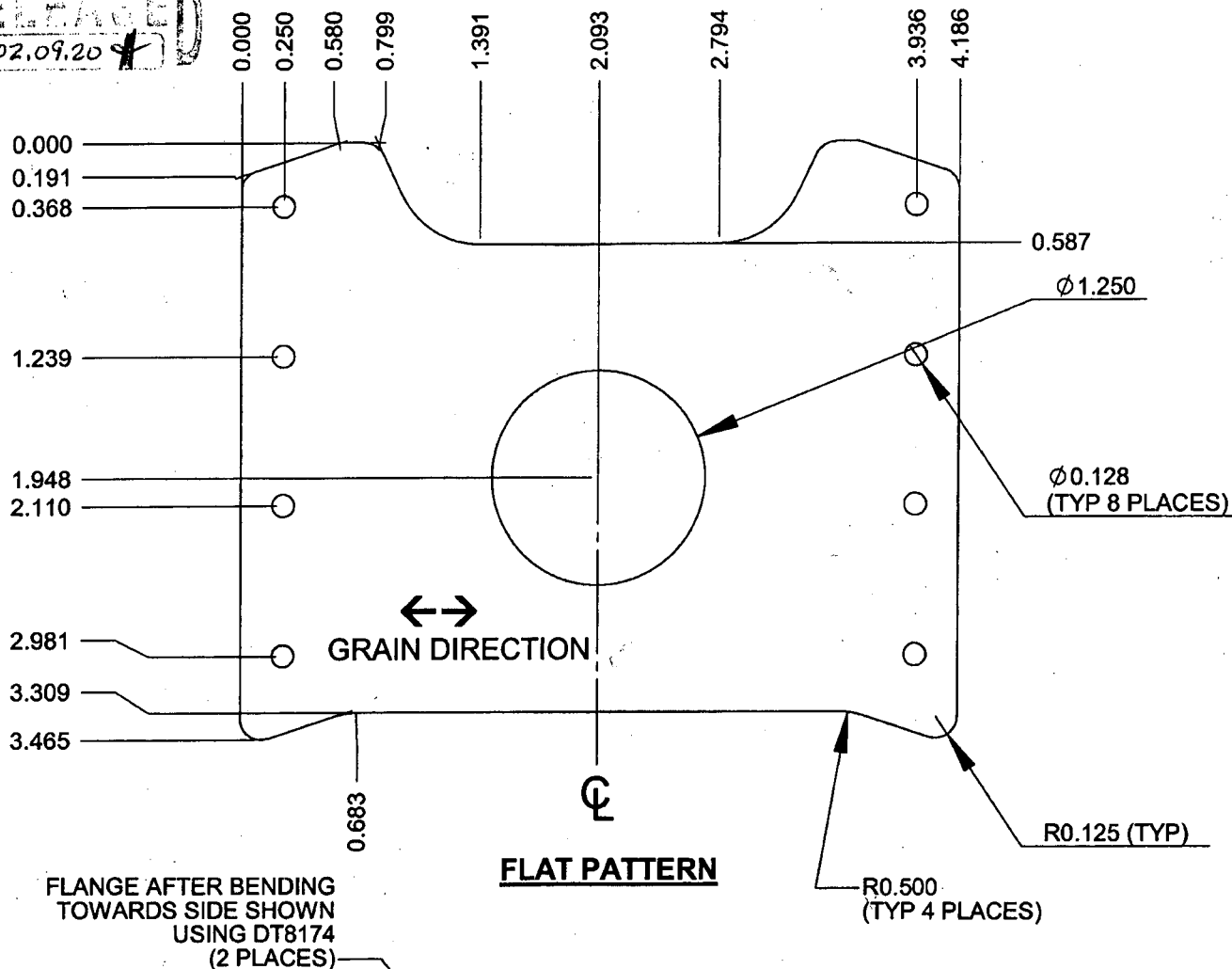
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

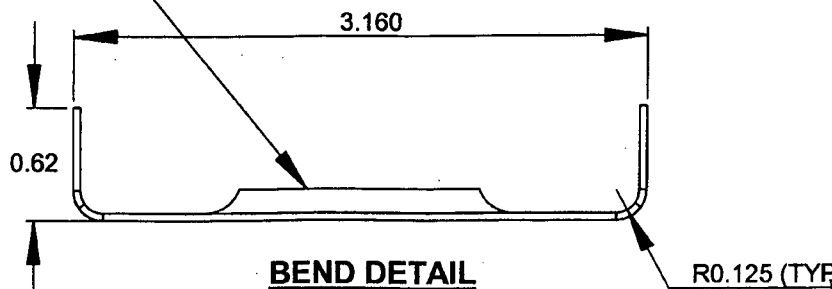
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02.09.20 *[Signature]*



UNDER REVIEW

06.06.02 CB  
material change

*CP* 06.06.15



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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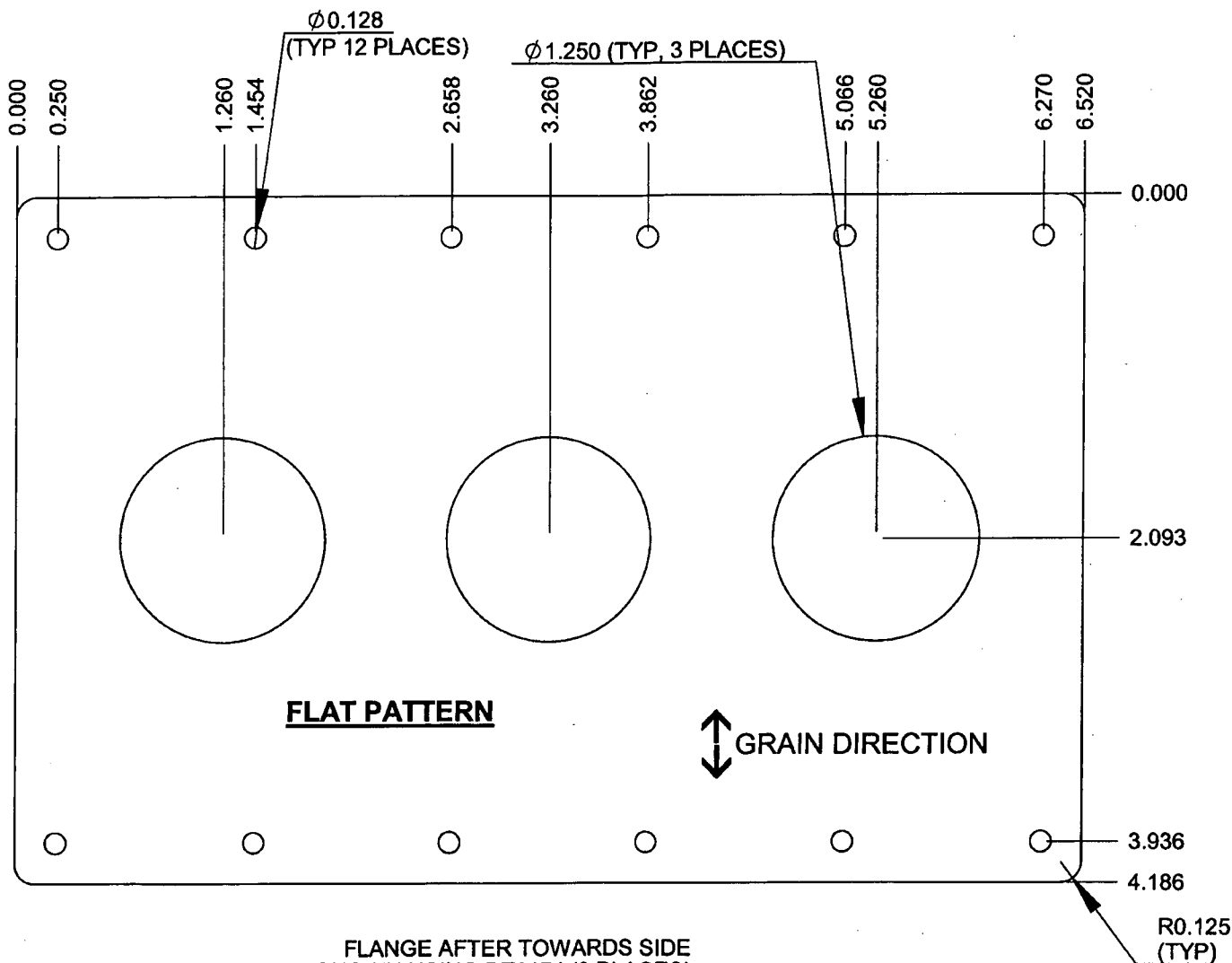
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02.09.20

**DART**



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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. <b>D3065</b>	REV. A SHEET 3 OF 5
DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



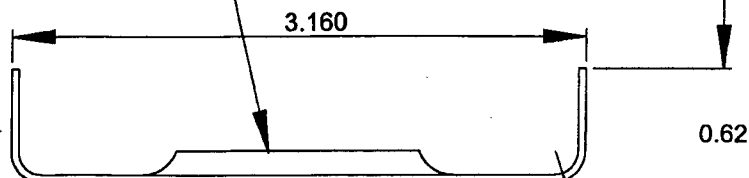
FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

**UNDER REVIEW**

06.06.07 CD

material change

OK *CP* 06.06.11



**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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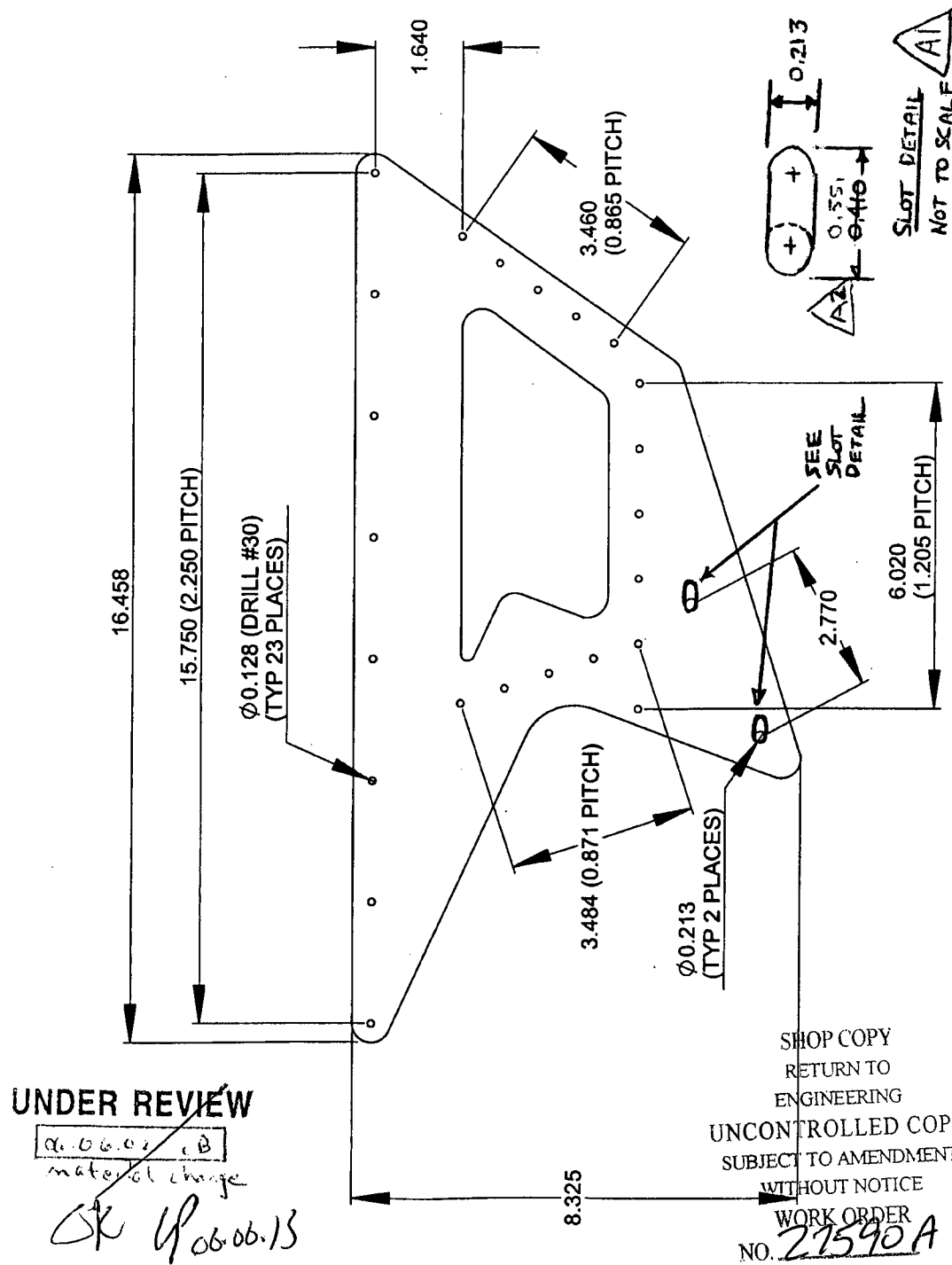
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DATE <b>02.09.11</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:3

RELEASED  
02.09.20 *[Signature]*

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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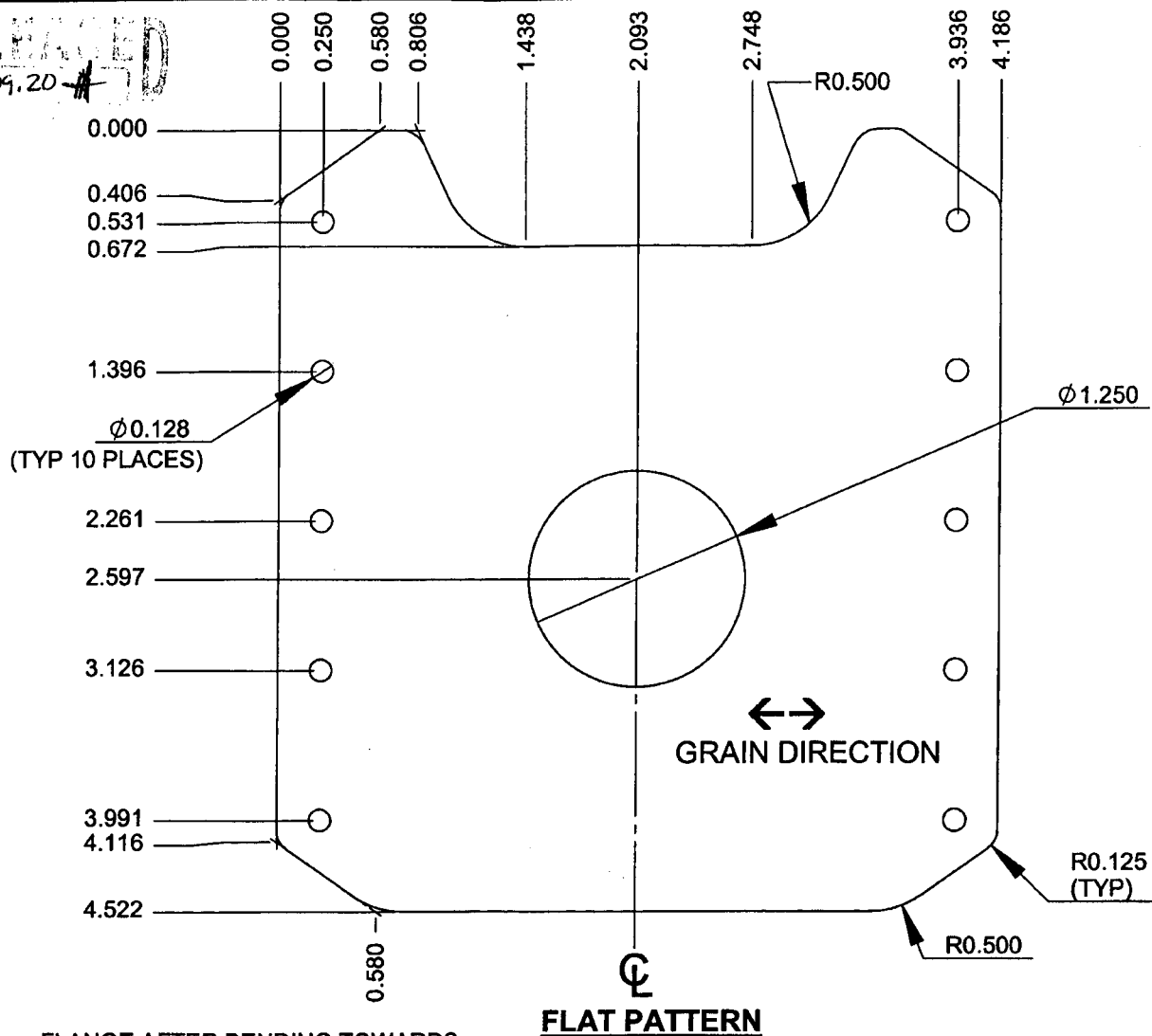
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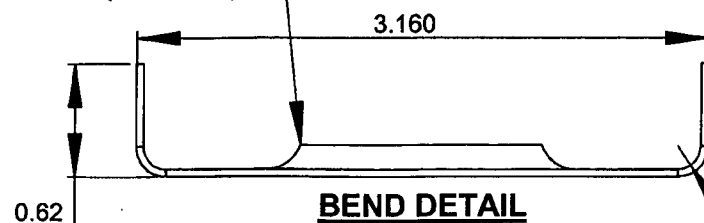
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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

RELEASED  
02.09.20

**UNDER REVIEW**

change material

OK UP 06.06.15

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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3040 TO AMENDMENT  
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